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D3913-041

Job Sheet 183122



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP Rev:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/21/18	0.00	0.00	Start Up Large Fab-5		CC
100	Large Fab	1 pcs		9/21/18	0.00	10.00	Large Fab 1		CC
110	QC	1 pcs		9/21/18	0.00	0.00	QC9		
120	QC	1 pcs		9/21/18	0.00	0.00	QC5		
125	HandFinish	1 pcs		9/21/18	0.00	0.29	HandFinish2		SEP 18-09-20
130	Powdercoat	1 pcs		9/21/18	0.00	0.93	Powdercoat2		BR 18-09-20
135	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging1		AL 18-10-01
140	QC	1 pcs		9/21/18	0.00	0.00	QC3		LY 18-10-01
150	HandFinish	1 pcs		9/21/18	0.00	0.50	HandFinish4		LY 18-10-01
160	QC	1 pcs		9/21/18	0.00	0.00	QC5		21 OCT 01 2018
170	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging3-2		21 OCT 01 2018
180	QC21-SA	1 Ea		9/21/18	0.00	0.00	QC21		21 OCT 01 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 83893 START 11:10 OUT: 375° FINISH: 11:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5108275
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5104485
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5106941
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5105281
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5110912
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5099924
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5108326

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5097017-1x
5089804
5106776
5106778
5089950
5089248-1
F86435
5076007
5078257
5108666
5072828

Job Allocations

005720

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	94	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-7	2	16	0
	D3913-9	1	12	0
	D3916-041	2	18	0
	D3916-5	3	18	0
	D4016-1	3	10	0
	D4017-7	3	28	0
	D4017-9	2	20	0
	D4020-11	2	15	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4034-043	1	9	0
	D4672-1	2	24	0
	M304EX0.75-16F	33	2,246	0
150-HandFinish	AN3-10A	6	301	0
	D2931	2	958	0
	D4021-5	2	46	0
	MS20600-AD4W3	2	157	0
	MS21042L3	6	3,308	0
	NAS1149F0332P	12	1,625	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE

Work Order: _____	DISPOSITION:
Part No. _____	_____
NCR No. _____	U.S. Suspected Unapplied

Description Work Order Deviation

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

DART
AEROSPACE

Container No: S111446

Part: D3913 - 041
Job No: 183122
Serial No/Batch: S111446

Revision:
Inspector:
Exp Date:

Instructions: Various STC's

Date: 09/19/8

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Job No 183122

A shipping label with a barcode and text. The text "PART" is at the top in large, bold, black letters. Below it, "FACE" is partially visible. The main text reads "Master Unit 005422" in a large, bold, black font. Below this, "oval" is written in a smaller, black font. A barcode is located at the bottom of the label.

Approval